

Work Order ID 54646

December 15, 2009 12:32:36 PM



Page 1

Item ID: D212-722-011

Accept



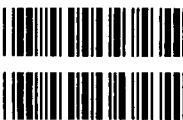
Setup Start



Revision ID:

Item Name: Avionics Console

Stop



Start Date: 12/16/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 12/29/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: MF

Date: 09-12-15

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D3363	Rev C
-------	-------

100	0.00
-----	------

	DOCUMENT CONTROL
--	------------------

DC	0.00
----	------

Document Control	Photocopy bluefile and create labels per PPP D212-722-011 CHG002
------------------	--

for BG 09/12/15
S 06/01

110	0.00
-----	------

	Small Fab
--	-----------

Small Fab	0.00
-----------	------

Small Fab	Memo 1-Cut (2) D3360-1, (2) D3360-3 & (2) D3360-5 to length as per Dwg D3360Material: 6063-T52 Aluminum angle 3/4" x 3/4" x 0.063" wall 1/2-Cut (1) D3361-1 to length as per Dwg D3361Material: 6063-T52 Aluminum channel 3/4" x 3/4" x 0.125" wall 1/3-Deburr D3360-1/-
-----------	--

EP 09/12/16 ④

120	0.00
-----	------

	Chemical Conversion Coat per QSI005 4.1
--	---

HandFinish	0.00
------------	------

Hand Finishing	Memo
----------------	------

BK 09-12-16 ④

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54646

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Page 2

Item ID: D212-722-011

Accept



Setup Start



Revision ID:

Item Name: Avionics Console

Stop



Start Date: 12/16/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 12/29/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____

Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDQC
Quality ControlOperation
Description

QC3- Inspect Part Finish

Set Up/
Run Hours

0.00

Draw
Number

Rev.

Plan
CodeAccept
QtyReject
Qty

0

Reject
Number

0

Insp.
Stamp

0.00

=> 11 09-12-16

(4) 0

140

Small Fab
Small Fab

Small Fab

0.00

Memo

0.00

1-Cut (2) D3362-1 to length as per Dwg D3362 Material: Dzus Fastener Rail
Mount Dzus Rails to DT8957 (Radio) and transfer drill into console.
Identify as D3363-041

150

QC
Quality Control

QC5- Inspect part completeness to step on W/O

0.00

=> S101021

Memo

0.00

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D212-722-011 PAR #: _____ Fault Category: Small Fab NCR: Yes No DQA: _____ Date: 10-02-10
 Resolution: re work Disposition: re-work QA: N/C Closed: _____ Date: 10/02/10

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/01/10	140	After transfer drilling of D33621 to D3363 or 1 employee notices that the part was in the wrong orientation to what the Drv. calls for.	AB 02/02/12	Build Alu in Alu into hub. → Drill 4 holes on 4 corners with weld per QSI 2004	AB 10/01/10 10/01/10	S 10-1121	AB 02/02/12	S 10/01/10
		"Drill this the 'Rando' will not fit/align correctly. At +4 const R.L. Lack of attention when transfer drilling."	AB 02/02/12	→ <u>A/E M111311</u> → Beams welds flat on both sides → Re-drill correctly	AB 10/01/10 10/01/10	S 10-1121	AB 02/02/12	S 10/01/10
			AB 02/02/12	→ touch up Alu on both sides "neatly" Added information on routing card	AB 10/01/10 10/01/10	AB 10/01/10	AB 02/02/12	S 10/01/10

NOTE: Date & initial all entries

Work Order ID 54646

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Item ID: D212-722-011

Accept



Setup

Start



Revision ID:

Item Name: Avionics Console

Stop



Start Date: 12/16/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 12/29/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160



Packaging

Packaging

Operation
Description

Pick Kit

Set Up/
Run Hours

0.00

Draw
Number

Rev.

Draw
Plan
Code

Qty

Accept
QtyReject
QtyReject
NumberReject
NumberInsp.
Stamp

170



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

0.00

180



Packaging

Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPP D212-722-011

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 54646

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Revision ID:

Item Name: Avionics Console

Stop



Start Date: 12/16/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 12/29/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

190



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Draw
Number

Rev.

Draw
Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Memo

0.00

6/6/03 AJ

MF

10-02-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 15, 2009 12:32:36 PM

Page 1

Work Order ID: 54646



Parent Item: D212-722-011



Parent Item Name: Avionics Console

Start Date: 12/16/2009

Required Date: 12/29/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3363-1 		Manufactured	No			140	Each	1.0000	4.0000			

Console

Warehouse

Location

Main Warehouse

B 53029

4

8509/12/18

ST

1

37215

1

M6063T5A0.750W.063



Angle6063T5 .750 X.750 X.063w

Purchased

No

M6063T5C.75X.75W.1

25



6063 CHANNEL.750 X.750 X.125w

Warehouse

Location

Main Warehouse

Loc Qty

Loc Code

MAT

106.9

113006

1.9

113134

105

29.05

Purchased

No

25



6063 CHANNEL.750 X.750 X.125w

Warehouse

Location

Main Warehouse

Loc Qty

Loc Code

MAT

21.904

107435

5.904

112040

16

3,316

8509/12/16

3,316

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 54646



Parent Item: D212-722-011



Parent Item Name: Avionics Console

Start Date: 12/16/2009

Required Date: 12/29/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS20426AD4-5



Purchased

No

140

Each

7,726.000 176.0000

Rivet



EP/10/01/07

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST

7726

4067

1093

6733

1651

6874

4982

MS20426AD4-6



Purchased

No

170

Each

3,639.000 36.0000

Rivet



EP/10/01/07

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST

3639

100151

27

103395

14

110139

3571

2525

27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

December 15, 2009 12:32:36 PM

Page 3

Work Order ID: 54646



Parent Item: D212-722-011



Parent Item Name: Avionics Console

Start Date: 12/16/2009

Required Date: 12/29/2009

Comments:

Start Qty: 4.00 ✓

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
PFSC35-38A-84 Dzus 1/4 turn fastener		Purchased		No		100	Each	66.0000	32.0000		12/10/29 (4)	

Warehouse

Location

Main Warehouse

ST 66

111779 16

112772 50

111779 40
112772 284

PR35-1

Purchased

No

140

f 6.2568 1.3332

DZUS FASTENER RAIL

Warehouse

Location

Main Warehouse

ST 6.2568

107913 5.8368

17763 0.42

1,332

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

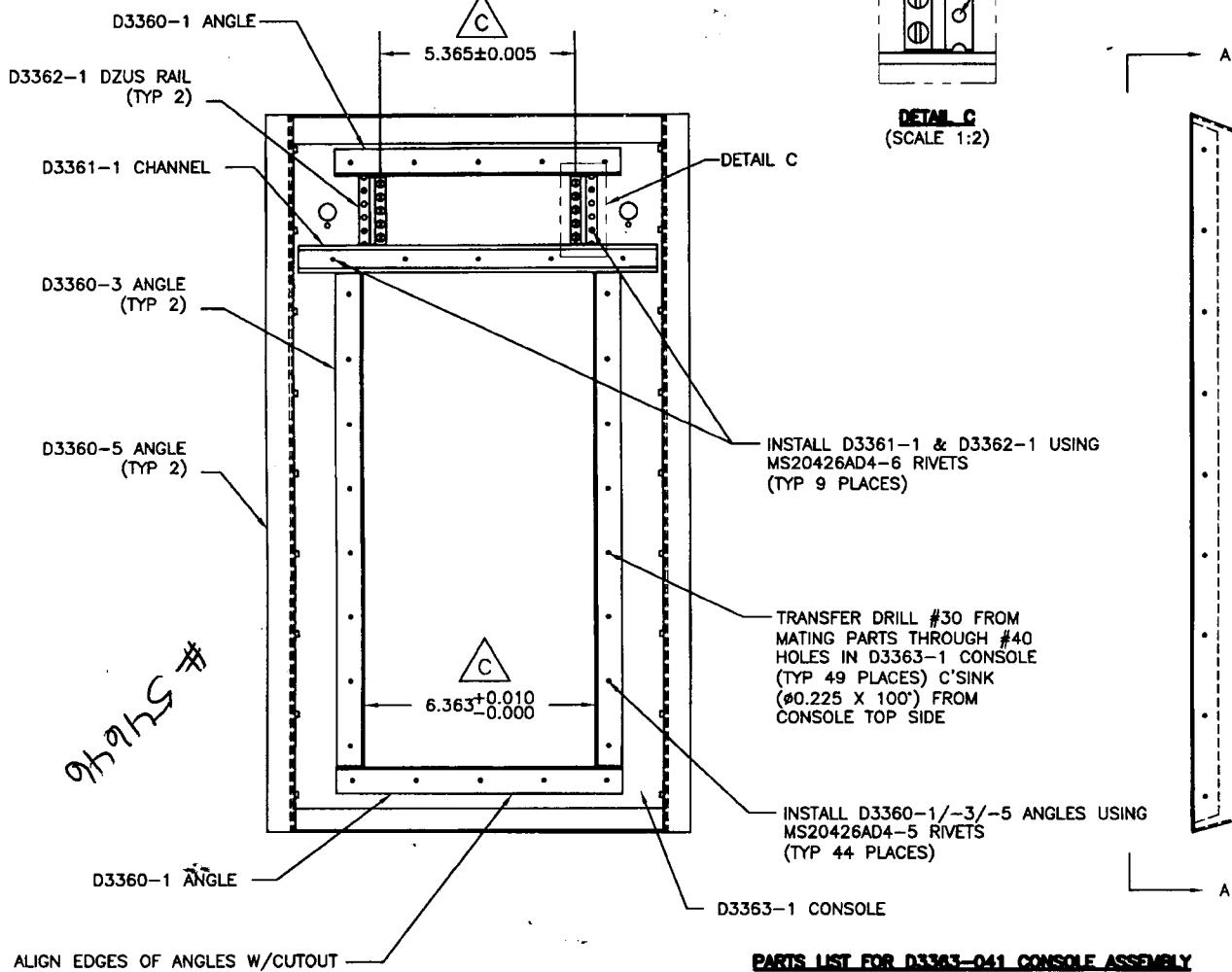
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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DART



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PARTS LIST FOR D3363-041 CONSOLE ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
1	D3363-041	CONSOLE ASSEMBLY
2	D3360-1	ANGLE
2	D3360-3	ANGLE
2	D3360-5	ANGLE
1	D3361-1	CHANNEL
2	D3362-1	RAIL
1	D3363-1	CONSOLE
44	MS20426AD4-5	RIVET
9	MS20426AD4-6	RIVET

D3363-041 CONSOLE ASSEMBLY

- 1) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 2) IDENTIFY WITH DART P/N D3363-041 AND B/N BXXXXX USING FINE POINT PERMANENT INK MARKER
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

DESIGN REV	DRAWN BY REV	DART AEROSPACE LTD	
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	
		DRAWING NO.	REV. C
DATE 07.01.26	DATE 07.01.26	TITLE D3363 CONSOLE ASSEMBLY	SCALE 1.5
A	04.11.29	NEW ISSUE	
B	05.03.28	INCREASE WIDTH BY 0.125	
C	07.01.26	T'DRILL DZUS RAIL, WIDEN BASE CUTOUT	

RELEASED
07.06.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

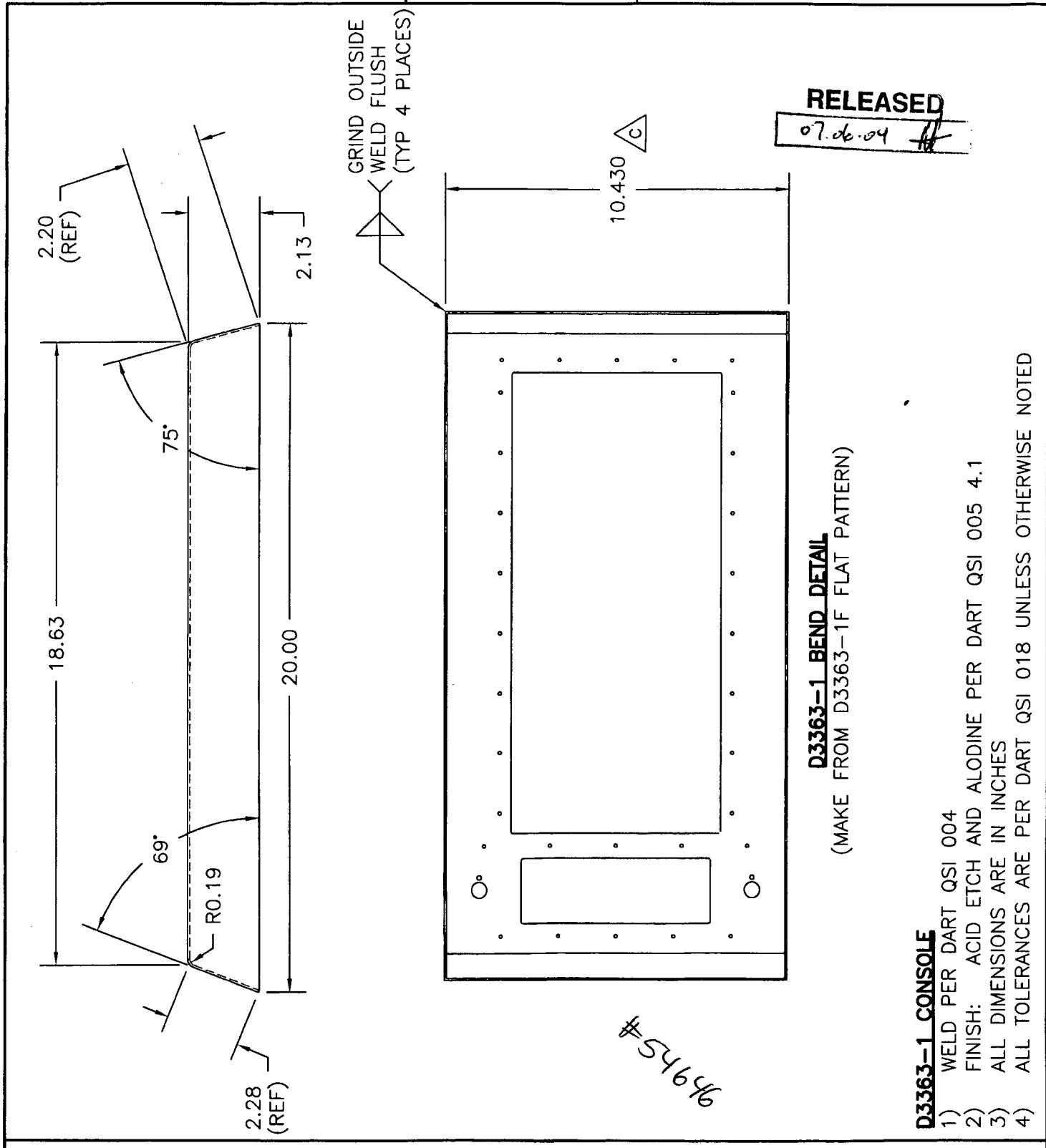
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3363	REV. C SHEET 2 OF 3
DATE 07.01.26		TITLE CONSOLE ASSEMBLY	SCALE 1:4

**D3363-1 CONSOLE**

- 1) WELD PER DART QSI 004
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

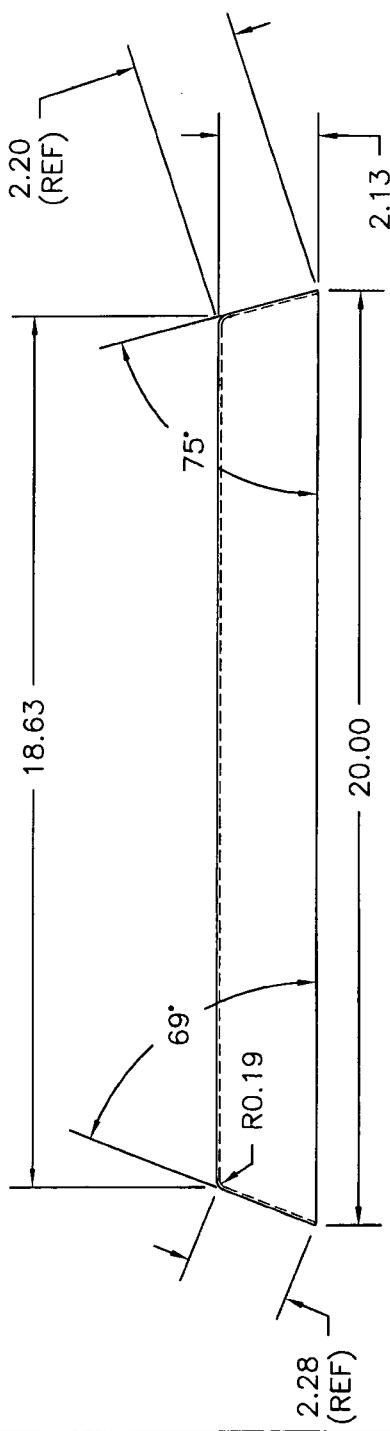
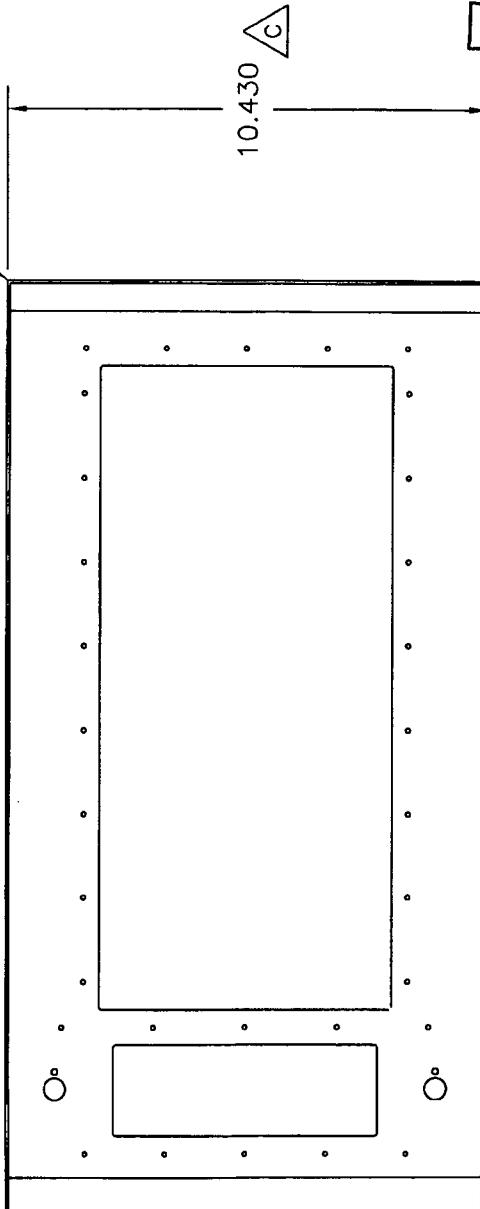
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3363
DATE 07.01.26		REV. C SHEET 2 OF 3 TITLE SCALE 1:4 CONSOLE ASSEMBLY

GRIND OUTSIDE
WELD FLUSH
(TYP 4 PLACES)**D3363-1 BEND DETAIL**
(MAKE FROM D3363-1F FLAT PATTERN)**D3363-1 CONSOLE**

- 1) WELD PER DART QSI 004
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

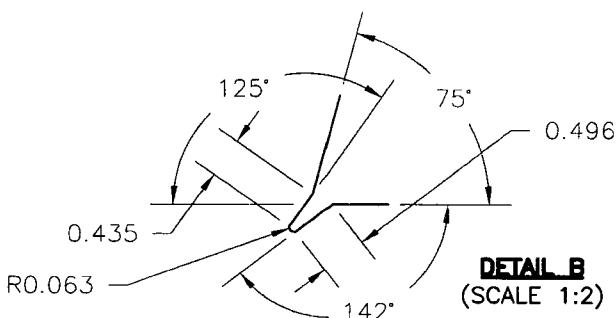
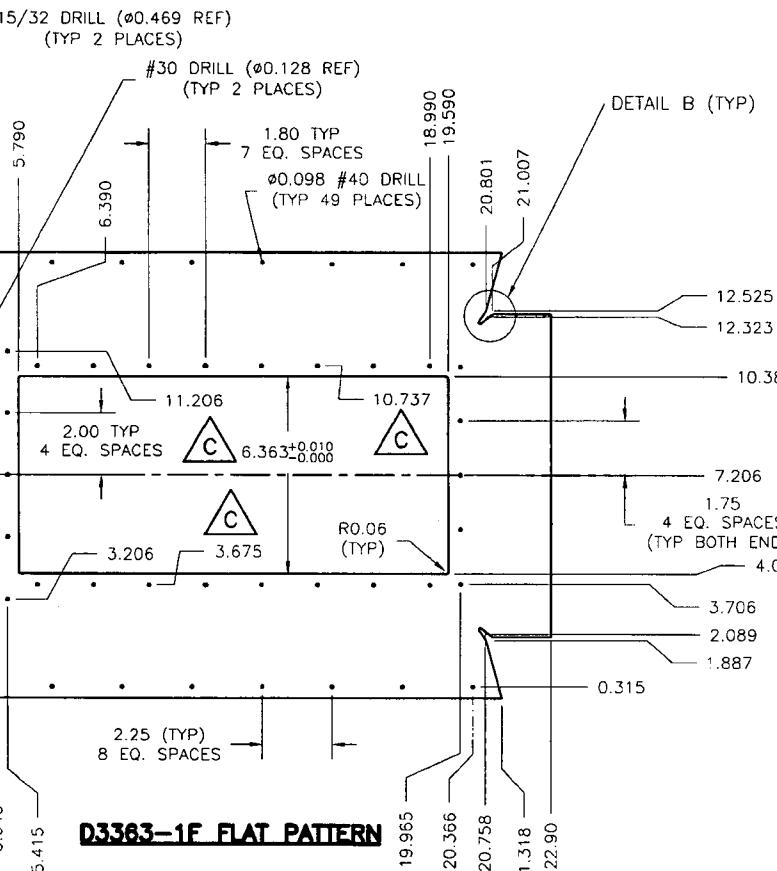
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN BY	DRAWN BY	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
1	CH	D3363
DATE		07.01.26
TITLE		CONSOLE ASSEMBLY
SCALE		1:6

07.06.04
RELEASED



D3363-1F CONSOLE (FLAT PATTERN)

- 1) MATERIAL: 6061-T6/T651 ALUMINUM 0.063 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) PART IS SYMMETRICAL ABOUT CENTERLINE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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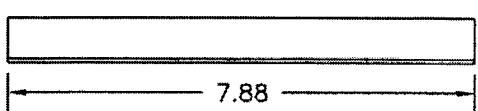
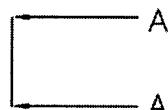
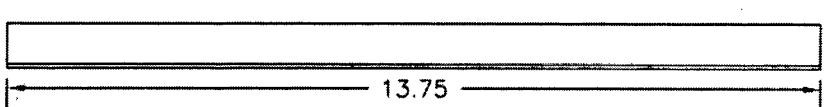
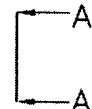
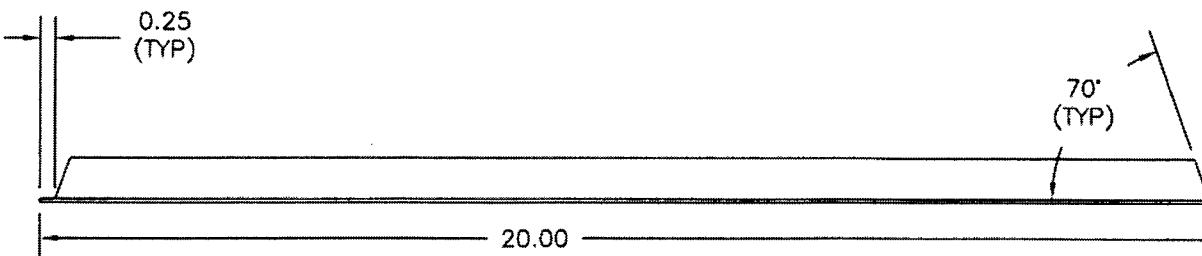
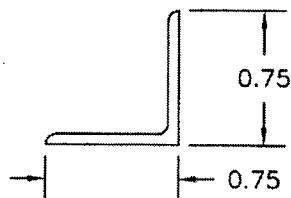
DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3360	REV. A	SHEET 1 OF 1
DATE 04.11.29		TITLE ANGLE	SCALE	1:12
A	04.11.29	NEW ISSUE		

RELEASED

05-03-31 *CH*

#54646

D3360-1
(SCALE 1:3)D3360-3
(SCALE 1:3)D3360-5
(SCALE 1:3)SECTION A-A
(SCALE 1:1)D3360-1/-3/-5 ANGLE

- 1) CUT LENGTH/SHAPE PER DIAGRAM
- 2) MATERIAL: 6063-T52 ALUMINUM
STOCK SIZE: 3/4" x 3/4" x 0.063" ANGLE EXTRUSION
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

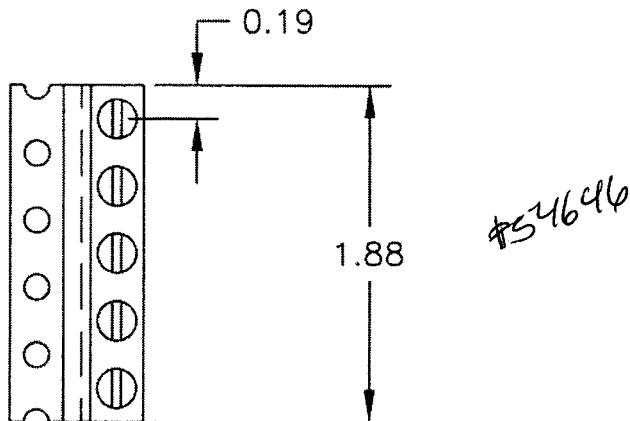
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DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3362	REV. A	SHEET 1 OF 1
DATE 04.11.29		TITLE RAIL	SCALE 1:1	
	A	04.11.29	NEW ISSUE	

RELEASED05.03.31 *[initials]*D3362-1 RAIL

- 1) CUT LENGTH/SHAPE PER DIAGRAM
- 2) MAKE FROM DZUS RAIL P/N "PR 3-1/2-1" OR PR-35-1
- 3) TOLERANCES ARE PER DART QSI 018
- 4) ALL DIMENSIONS ARE IN INCHES

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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4.0 WEIGHT AND BALANCE

The following weight and balance information does not include the installation of any equipment in the D212-722-011 Avionics Riser Console Assembly.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D212-722-011 Avionics Riser Console	2.3 lb 1.1 kg	0 in 0 m	0 lb-in 0 kg-m	37 in 0.9 m	85.1 lb-in 1.0 kg-m

5.0 PARTS LIST

Qty - 011	Part Number	Description
X	D212-722-011	AVIONICS RISER CONSOLE
1	D3363-041	CONSOLE ASSEMBLY
8	PFSC35-38A	DZUS FASTENERS
REF	D1038-58	FASTENER RAIL
REF	D1038-58B	FASTENER RAIL, BLACK
REF	PR35	DZUS RAIL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries